

Work Order ID 51279

August 13, 2009 10:55:41 AM

Page 1

Item ID: D205-634-041

Accept

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/13/09 Start Qty: 1.00

Required Date: 10/13/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

D

H 9/8/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



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Start Date: 8/13/09 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

51

BE 08/08/26

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8 08/08/26

50

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

m111682

BE 08/08/26

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

m111682

BE 09/08/26

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 09/08/26

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



0.00 => 508/08/27

QC

Memo

Quality Control



160

QC5- Inspect part completeness to step on W/O

0.00



0.00 => 508/08/27

QC

Memo

Quality Control



170

Pressure Wash per QSI005 4.3

0.00



0.00 => 11 09/08/31

HandFinish

Memo

Hand Finishing



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

M112260

0.00

Powder Coating

START TIME:

1:45pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:15pm

⇒ JH 09/08/31

1 0

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BL 09-09-01

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391

Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391

Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M112106

98 09/09/01 (21)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 10/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

→ 8/13/09



220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

PP 51271

9/9/08

QSI

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/30

PL 09-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

August 13, 2009 10:55:40 AM

Page 1

Work Order ID: 51279

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2580-1RevD

Manufactured

No

110

Each

8.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

6

50757

6

Main Warehouse

ST

2

50758

2

B50976

D

129/8/24

D2576-3RevG

Manufactured

No

140

Each

147.0000

1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

147

43504

46

46661

101

1

BE 9/3/26

Picklist Print

August 13, 2009 10:55:40 AM

Work Order ID: 51279

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	92.0000	20.0000			
												
Crossbolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

92

43988

4

46434

4

46956

2

47797

28

48272

54

2 51315 (20) RE 09/08/26

D2855RevA

Manufactured No

200

Each

37.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6

37

50513

37

XL 91 09/09/01

Picklist Print

August 13, 2009 10:55:40 AM

Page 3

Work Order ID: 51279

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			200	Each	2,540.000	2.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2540

100188

226

105057

2246

15205

68

x2 49 09/09/01

AN960JD10L

Purchased

No

200

Each

6,733.000 2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6733

101291

16

104885

153

105793

236

109632

1328

110985

5000

x2 49 09/09/01

August 13, 2009 10:55:40 AM

Shop Packet Print

Page 3

Picklist Print

Page 4

August 13, 2009 10:55:40 AM

Work Order ID: 51279

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Comments:

Start Date: 8/13/09

Required Date: 10/13/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS7-1032-130 Purchased No 200 Each 3,628.000 50.0000



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3628

105855 16

108606 52

111529 1560

111779 2000

AN3C4A Purchased No 200 Each 1,222.000 50.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1222

112082 40

112314 1182

50x 11/09/09/01

50x 11/09/09/01

August 13, 2009 10:55:40 AM

Shop Packet Print

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Picklist Print

August 13, 2009 10:55:40 AM

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Parent Item Name: Replacement Skidtube


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Required Date: 10/13/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			200	Each	3,764.000	50.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

3664

112116

3664

D3566-13RevC

Manufactured

No

200

Each

29.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

45717

1

46889

2

48166

10

50265

16

50x M 09/09/09

x1 M 09/09/09

Picklist Print

August 13, 2009 10:55:40 AM

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Parent Item Name: Replacement Skidtube

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D3566-5RevC 	*	Manufactured	No			200	Each	4.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B51260	
ST	4	
36113	1	
46186	1	
47318	1	
48167	1	

x1 M 09/09/01

D3566-1RevC 	*	Manufactured	No			200	Each	13.0000	2.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B51259	
ST	13	
46349	1	
47434	2	
48557	3	
51218	7	

x1 M 09/09/01

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD	✓	Manufactured	No			200	Each	15.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

45823

48553

50112

351256


15

1

4

10

x1 21 09/09/01

D3564-13RevD		Manufactured	No			200	Each	39.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

48554

50270

Main Warehouse

ST

45409

46495

47867

24

2

22

x1 21 09/09/01

Picklist Print .

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3564-9RevD

X

Manufactured

No

200

Each

3.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44659

45825

48556

B51258

3

1

1

1

X1 41 09/09/01

D3564-5RevD

X

Manufactured

No

200

Each

6.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

34806

Main Warehouse

FP19

48555

Main Warehouse

ST

45824

47433

B51257

2

2

2

2

2

1

1

X1 41 09/09/01

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Shop Packet Print

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D2594-3RevC		Manufactured	No			200	Each	670.0000	16.0000			
												
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 670

27168 44

29908 626

D2594-1RevC

Manufactured No

200

Each

476.0000

16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 476

42221 16

42807 92

43884 3

46435 2

47251 363

XLG 41 09/09/09

XLG 41 09/09/09

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DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

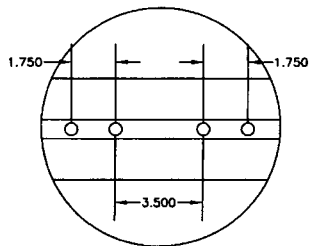
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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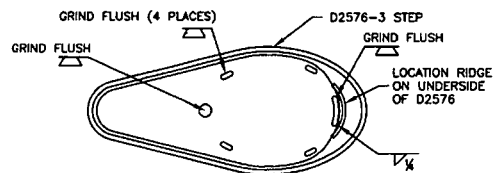
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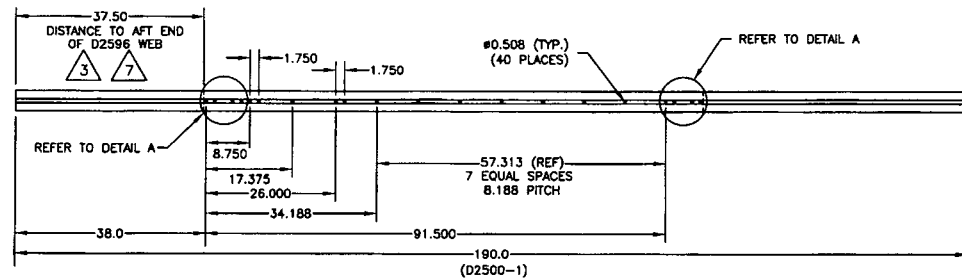
DETAIL A
SCALE 5:24



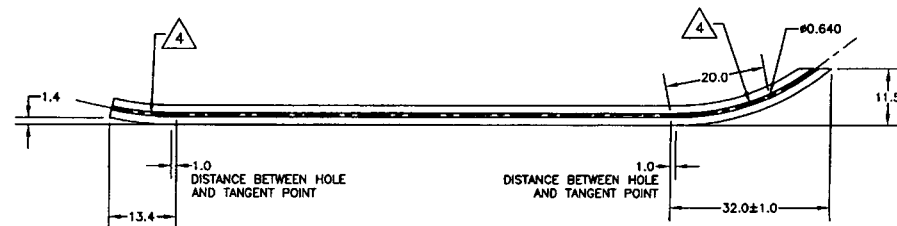
DETAIL B
SCALE 5:24



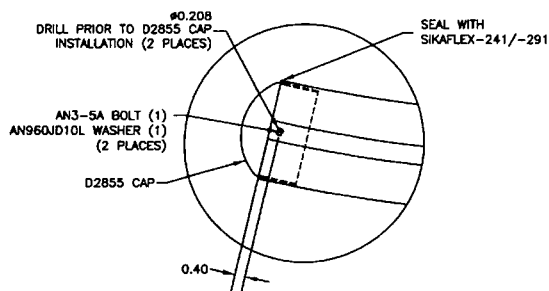
D2580-1 DRILLING DETAIL



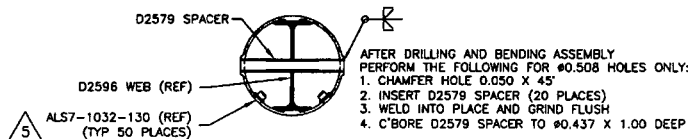
D2580-1 BENDING AND CUTTING DETAIL



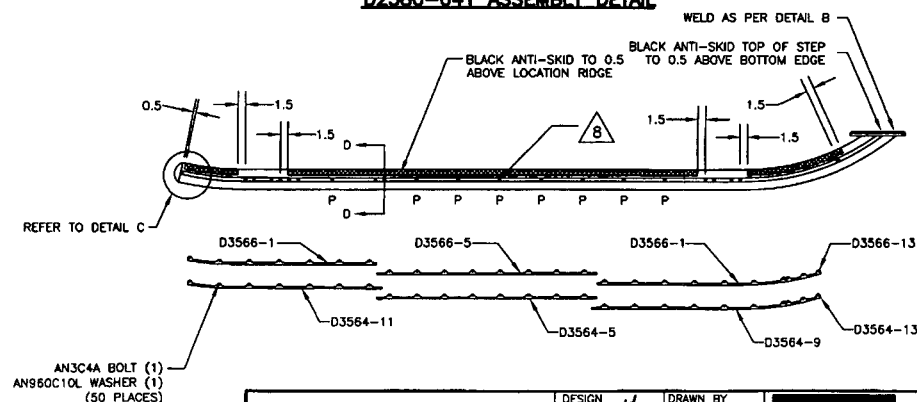
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	07.02.27	D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07 Dec 78

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{16}$

Diagram illustrating the assembly of a circular component, likely a fuel tank or cover, showing the following components and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Indicated by a line pointing to a small circle on the top edge of the component.
- SEAL WITH SIKAFLEX-241/-291**: Indicated by a line pointing to the outer edge of the component.
- AN3-5A BOLT (1)**: Indicated by a line pointing to a bolt on the left side of the component.
- AN960JD10L WASHER (1) (2 PLACES)**: Indicated by a line pointing to a washer on the left side of the component.
- D2855 CAP**: Indicated by a line pointing to the top edge of the component.
- SEE NOTE ii)**: Indicated by a line pointing to a small circle on the right side of the component.
- 0.40**: Dimension indicating the thickness of the component, shown at the bottom.

Diagram of a circular web assembly with labels:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

5

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437 \times 1.00$ DEEP

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[illegible]

Technical drawing of a propeller shaft with the following dimensions and callouts:

- Overall length: 51.340
- Distance from left end to first hole: 5.985
- Distance between first and second hole: 5.338 (REF)
- Distance from second hole to third hole: 3.630 (REF)
- Distance from third hole to fourth hole: 39.580
- Distance from fourth hole to fifth hole: 5.915
- Distance from fifth hole to sixth hole: 20.0
- Distance from sixth hole to seventh hole: 1.0
- Distance from seventh hole to eighth hole: 1.0
- Distance from eighth hole to ninth hole: 32.0 ± 1.0
- Callout 4: Points to the left end of the shaft.
- Callout 4: Points to the right end of the shaft.
- Callout 4: Points to the first hole.
- Callout 4: Points to the second hole.
- Callout 4: Points to the third hole.
- Callout 4: Points to the fourth hole.
- Callout 4: Points to the fifth hole.
- Callout 4: Points to the sixth hole.
- Callout 4: Points to the seventh hole.
- Callout 4: Points to the eighth hole.
- Callout 4: Points to the ninth hole.
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- Callout 4: Points to the eleventh hole.
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- Callout 4: Points to the thirteenth hole.
- Callout 4: Points to the fourteenth hole.
- Callout 4: Points to the fifteenth hole.
- Callout 4: Points to the sixteenth hole.
- Callout 4: Points to the seventeenth hole.
- Callout 4: Points to the eighteenth hole.
- Callout 4: Points to the nineteenth hole.
- Callout 4: Points to the twentieth hole.
- Callout 4: Points to the twenty-first hole.
- Callout 4: Points to the twenty-second hole.
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- Callout 4: Points to the twenty-fifth hole.
- Callout 4: Points to the twenty-sixth hole.
- Callout 4: Points to the twenty-seventh hole.
- Callout 4: Points to the twenty-eighth hole.
- Callout 4: Points to the twenty-ninth hole.
- Callout 4: Points to the thirtieth hole.
- Callout 4: Points to the thirty-first hole.
- Callout 4: Points to the thirty-second hole.
- Callout 4: Points to the thirty-third hole.
- Callout 4: Points to the thirty-fourth hole.
- Callout 4: Points to the thirty-fifth hole.
- Callout 4: Points to the thirty-sixth hole.
- Callout 4: Points to the thirty-seventh hole.
- Callout 4: Points to the thirty-eighth hole.
- Callout 4: Points to the thirty-ninth hole.
- Callout 4: Points to the fortieth hole.
- Callout 4: Points to the forty-first hole.
- Callout 4: Points to the forty-second hole.
- Callout 4: Points to the forty-third hole.
- Callout 4: Points to the forty-fourth hole.
- Callout 4: Points to the forty-fifth hole.
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- Callout 4: Points to the forty-seventh hole.
- Callout 4: Points to the forty-eighth hole.
- Callout 4: Points to the forty-ninth hole.
- Callout 4: Points to the fiftieth hole.
- Callout 4: Points to the fifty-first hole.
- Callout 4: Points to the fifty-second hole.
- Callout 4: Points to the fifty-third hole.
- Callout 4: Points to the fifty-fourth hole.
- Callout 4: Points to the fifty-fifth hole.
- Callout 4: Points to the fifty-sixth hole.
- Callout 4: Points to the fifty-seventh hole.
- Callout 4: Points to the fifty-eighth hole.
- Callout 4: Points to the fifty-ninth hole.
- Callout 4: Points to the sixtieth hole.
- Callout 4: Points to the sixty-first hole.
- Callout 4: Points to the sixty-second hole.
- Callout 4: Points to the sixty-third hole.
- Callout 4: Points to the sixty-fourth hole.
- Callout 4: Points to the sixty-fifth hole.
- Callout 4: Points to the sixty-sixth hole.
- Callout 4: Points to the sixty-seventh hole.
- Callout 4: Points to the sixty-eighth hole.
- Callout 4: Points to the sixty-ninth hole.
- Callout 4: Points to the seventieth hole.
- Callout 4: Points to the seventy-first hole.
- Callout 4: Points to the seventy-second hole.
- Callout 4: Points to the seventy-third hole.
- Callout 4: Points to the seventy-fourth hole.
- Callout 4: Points to the seventy-fifth hole.
- Callout 4: Points to the seventy-sixth hole.
- Callout 4: Points to the seventy-seventh hole.
- Callout 4: Points to the seventy-eighth hole.
- Callout 4: Points to the seventy-ninth hole.
- Callout 4: Points to the eightieth hole.
- Callout 4: Points to the eighty-first hole.
- Callout 4: Points to the eighty-second hole.
- Callout 4: Points to the eighty-third hole.
- Callout 4: Points to the eighty-fourth hole.
- Callout 4: Points to the eighty-fifth hole.
- Callout 4: Points to the eighty-sixth hole.
- Callout 4: Points to the eighty-seventh hole.
- Callout 4: Points to the eighty-eighth hole.
- Callout 4: Points to the eighty-ninth hole.
- Callout 4: Points to the ninetieth hole.
- Callout 4: Points to the ninety-first hole.
- Callout 4: Points to the ninety-second hole.
- Callout 4: Points to the ninety-third hole.
- Callout 4: Points to the ninety-fourth hole.
- Callout 4: Points to the ninety-fifth hole.
- Callout 4: Points to the ninety-sixth hole.
- Callout 4: Points to the ninety-seventh hole.
- Callout 4: Points to the ninety-eighth hole.
- Callout 4: Points to the ninety-ninth hole.
- Callout 4: Points to the one hundredth hole.

HULL ASSEMBLY DETAIL

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)


DESIGN	DRAWN BY
--------	----------

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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	APPROVED <i>[Signature]</i>

 DART AEROSPACE LTD. WARRICKSBURY, ONTARIO, CANADA	
DRAWING NO.	REV. C
D2580	SHEET 3 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

NO. 206

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 50844
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[] fail[]
pass[] fail[]
pass[☒] fail[]
pass[] fail[]
pass[] fail[]
pass[] fail[]

Qualifier [Signature]

Date of Test Coupon 09.08.13

Welder [Signature]

Date of Test Coupon 09.08.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld